

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017106**Date Inspected:** 05-Sep-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Tao**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG COMPONENT**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Subhasis Bera was present during the times noted above for observations relative to the work being performed.

In process Inspection

Out Side Yard

This QA Inspector observed the following work in progress:

SMAW in the 4G position for the OBG segment 12AE, weld No. FB3006-001-165. The welder is identified as #054016. ZPMC QC is identified as Mr.Wang Xing Pin. The welding variables recorded by QC appear to comply with WPS-B-P-2214-B-U2-FCM.

SMAW in the 1G position for the OBG segment 12AE, weld No. SEG3001H-360. The welder is identified as #044779. ZPMC QC is identified as Mr.Wang Wai Ming. The welding variables recorded by QC appear to comply with WPS-B-P-2211-B-U2-FCM-1.

SMAW in the 4G position for the OBG segment 12AE, weld No. SEG3001J-360. The welder is identified as #044772. ZPMC QC is identified as Mr.Wang Wai Ming. The welding variables recorded by QC appear to comply with WPS-B-P-2214-B-U2-FCM-1.

SMAW in the 2G position for the OBG segment 12BE, weld No. SEG3002E-246. The welder is identified as #043661. ZPMC QC is identified as Mr.Wang Wai Ming. The welding variables recorded by QC appear to

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

comply with WPS-B-P-2212-Tc-U4b-FCM-1.

SMAW in the 2G position for the OBG segment 12BE, weld No. SEG3002F-247. The welder is identified as #043661. ZPMC QC is identified as Mr. Wang Wai Ming. The welding variables recorded by QC appear to comply with WPS-B-P-2212-Tc-U4b-FCM-1.

Bay#14

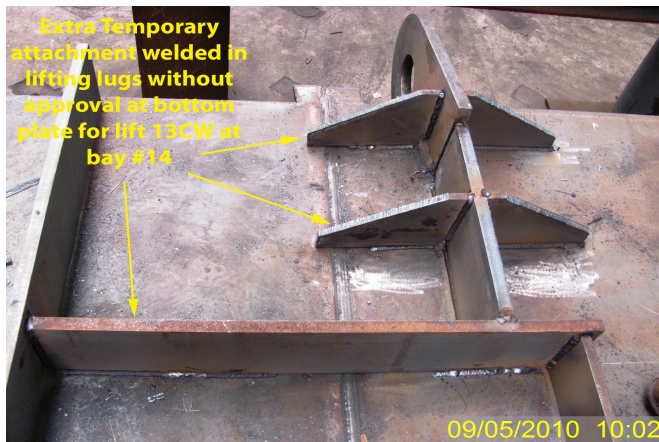
This QA Inspector observed the following work in progress:

During in process inspection the QA inspector observed that the ZPMC personnel performed extra welding for temporary attachment at bottom plate without any engineer approval at bay#14. This QA inspector informed to ZPMC QC personnel to provide details of temporary attachment area for future tracking .

Visual Inspection after Blast at 11AW

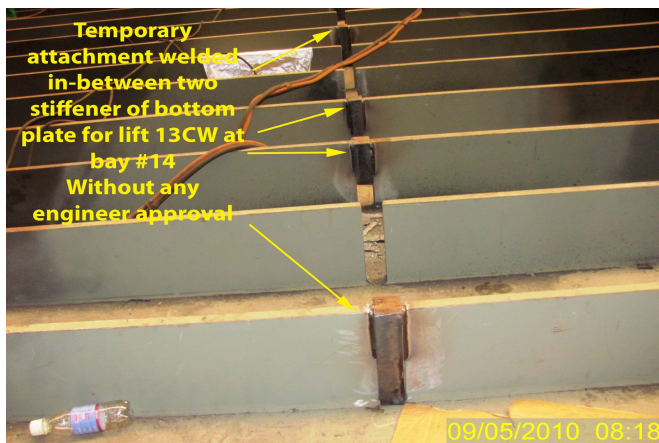
This Quality Assurance (QA) Inspector performed random visual inspection of OBG segment 11AW internal side panel and bottom panel surfaces after grit blasting in between panel point PP96 to PP97. Areas that marked for repair were recorded for future repair. Areas requiring additional grinding were marked by QA and repaired by ZPMC personnel. See the attached photo.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



WELDING INSPECTION REPORT

(Continued Page 3 of 3)



Summary of Conversations:

No relevant conversations

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Bera,Subhasis	Quality Assurance Inspector
Reviewed By:	Patterson,Rodney	QA Reviewer
